

Date: Monday, 2/5/2007 8:06:57 AM
 User: Kim Johnston

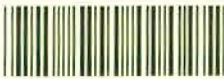
Process Sheet

SPLIT - 1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 30592	Part Number	: D2571
Estimate Number	: 10530	Drawing Number	: D2571 REV E
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 2/5/2007	Drawing Revision	: E
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 2/15/2007
Previous Run	: 30212	Type	: MACHINED PARTS
Written By	: <u>JA 07.02.05</u>	Qty:	12 Um: Each
Checked & Approved By	: <u>JA 07.02.05</u>		
Comment	: Est: 1 02:40.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
 7075-T7351 8.25X7.75X2.5
 Make from D6101-007 billet for D2571
 Ensure that grain is along 7.75" length
 Batch No: 25355

BG 07.04.11

9

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 330542 Double check by: J.F.

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

gml / BG 07.04.11 / Er (9)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

gml / BG 07.04.11 / Er (9)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

gml / BG 07.04.11 / Er (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: AD Date: 07/04/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 8:06:57 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 30592

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/04/16

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL

07/04/16

⑨

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

07-04-16 ⑨

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/04/16 ⑨

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/04/16 ⑨

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/17

Job Completion



07-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30592
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.748	1.749	1.745		
C	3.495	3.505		3.500	3.498	3.500	3.498		
D	1.745	1.755		1.750	1.748	1.749	1.749		
E	7.990	8.010		8.000	8.002	8.003	8.001		
F	0.490	0.510		.505	0.499	0.497	0.500		
G	0.257	0.262	DT8683	.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	.377	0.377	0.377	0.377		
I	0.490	0.510		.502	0.502	0.500	0.501		
J	1.174	1.184		1.180	1.177	1.177	1.178		
K	0.558	0.578		.570	0.568	0.564	0.565		
L	1.174	1.184		1.180	1.177	1.177	1.178		
M	1.490	1.500		1.497	1.493	1.494	1.492		
N	2.495	2.505		2.500	2.500	2.497	2.497		
O	3.869	3.879		3.875	3.872	3.871	3.871		
P	0.115	0.135		.133	0.133	0.129	0.128		
Q	0.115	0.135		.132	0.135	0.135	0.135		
R	0.240	0.260		.259	0.255	0.247	0.248		
S	0.115	0.135		.130	0.134	0.132	0.129		
T	0.178	0.198		.187	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.246	0.244	0.238	0.241		
W	0.115	0.135		.118	0.126	0.128	0.125		
X	0.308	0.313		.311	0.311	0.311	0.311		
Y	0.760	0.765		.764	0.765	0.765	0.761		
Z	0.352	0.372		.367	0.367	0.358	0.360		
AA	0.470	0.530		.500	0.500	0.500	0.500		
AB	0.615	0.635		.633	0.629	0.626	0.630		
AC	0.053	0.073		.063	0.063	0.063	0.063		
AD	0.240	0.260		.255	0.252	0.246	0.242		
AE	1.375	1.395		1.385	1.384	1.385	1.384		
AF	0.115	0.135		.130	0.135	0.135	0.134		
AG	0.240	0.280		.240	0.260	0.260	0.260		
AH	0.240	0.260		.258	0.256	0.245	0.248		
AI	2.000	2.020		2.002	2.000	2.000	2.000		
AJ	0.023	0.043		.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	BC / Ep
Date:	07.04.11 / 07.04.13

Audited by:	X SA
Date:	07.04.13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

11/10/11
23

DART AEROSPACE LTD	Work Order:	30592
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.446	0.446		
B	1.745	1.755		1.749	1.749	1.749	1.749		
C	3.495	3.505		3.499	3.499	3.506	3.506		
D	1.745	1.755		1.749	1.749	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		0.496	0.506	0.502	0.504		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.506	0.502	0.506	0.502		
J	1.174	1.184		1.177	1.178	1.178	1.178		
K	0.558	0.578		0.565	0.568	0.568	0.568		
L	1.174	1.184		1.177	1.178	1.178	1.178		
M	1.490	1.500		1.492	1.494	1.495	1.494		
N	2.495	2.505		2.497	2.500	2.500	2.500		
O	3.869	3.879		3.871	3.871	3.871	3.873		
P	0.115	0.135		0.128	0.129	0.124	0.128		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.248	0.249	0.245	0.245		
S	0.115	0.135		0.128	0.135	0.125	0.135		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.242	0.242	0.244	0.243		
W	0.115	0.135		0.130	0.131	0.132	0.133		
X	0.308	0.313		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.354	0.356	0.358		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.629	0.633	0.633	0.635		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.246	0.248	0.247		
AE	1.375	1.395		1.385	1.383	1.383	1.384		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.249	0.245	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	En 10ml
Date:	07/04/13 07/04/14

Audited by:	J.L
Date:	07/04/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 30592
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440					
B	1.745	1.755		1.749					
C	3.495	3.505		3.500					
D	1.745	1.755		1.750					
E	7.990	8.010		8.001					
F	0.490	0.510		0.507					
G	0.257	0.262	DT8683	0.259					
H	0.375	0.380	DT8684	0.376					
I	0.490	0.510		0.500					
J	1.174	1.184		1.178					
K	0.558	0.578		0.568					
L	1.174	1.184		1.178					
M	1.490	1.500		1.495					
N	2.495	2.505		2.500					
O	3.869	3.879		3.871					
P	0.115	0.135		0.127					
Q	0.115	0.135		0.135					
R	0.240	0.260		0.243					
S	0.115	0.135		0.135					
T	0.178	0.198		0.188					
U	2.940	2.980		2.968					
V	0.230	0.250		0.242					
W	0.115	0.135		0.132					
X	0.308	0.313		0.310					
Y	0.760	0.765		0.765					
Z	0.352	0.372		0.359					
AA	0.470	0.530		0.500					
AB	0.615	0.635		0.634					
AC	0.053	0.073		0.063					
AD	0.240	0.260		0.244					
AE	1.375	1.395		1.383					
AF	0.115	0.135		0.135					
AG	0.240	0.280		0.260					
AH	0.240	0.260		0.247					
AI	2.000	2.020		2.000					
AJ	0.023	0.043		0.033					
Accept/Reject									

Measured by:	Am
Date:	07/04/14

Audited by:	J.L
Date:	07/04/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.12

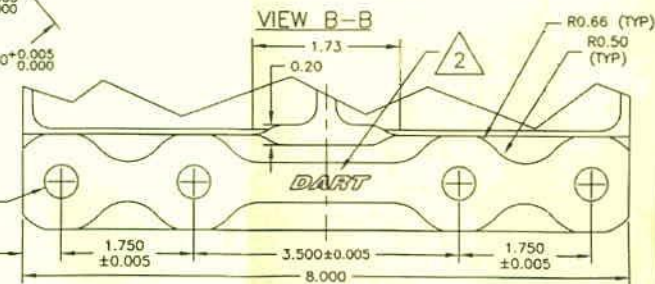
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

E

VIEW B-B

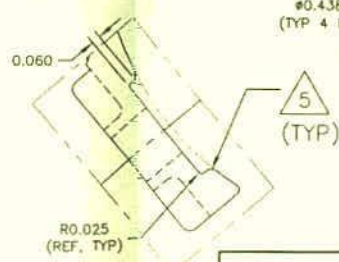


E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102, ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD.
CHECKED	#	APPROVED	#	DRAWING NO.	D2571
DATE	05.07.13	TITLE	OUTER FWD SADDLE		
				REV. E	SHEET 1 OF 1
				SCALE	2:3

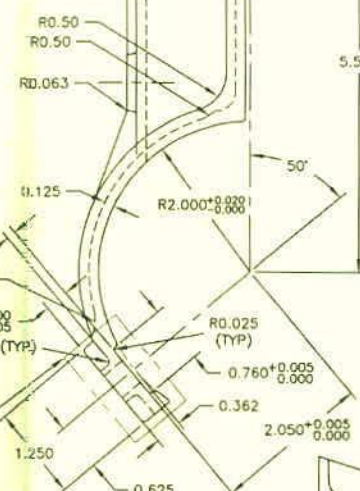
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DETAIL C
 SCALE 4:3



DETAIL C

B



5.500

50°

VIEW B-B

0.500

1.750 ±0.005

3.500 ±0.005

1.750 ±0.005

8.000

0.20

1.73

R0.66 (TYP)

R0.50 (TYP)

DART

0.250

0.240 FLAT ON RIDGE

0.750

2.960 ±0.020

R0.50 (TYP)

0.250 (TYP ALL RIDGES)

0.125

R0.50 (TYP)

R0.50 (TYP)

R0.188 (TYP AROUND POCKET)

0.063

1.573 (REF)

0.125

0.250

R1.385

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